

Work Order ID 67187

Wednesday, March 09, 2011 2:32:34 PM



Page 1

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	3/9/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	3/18/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-03-9	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9445 jig								
	****cut cutouts with zip cut as per dwg D3832****								
	3- remove from jig and weld lable plate as per dwg D2989								
	A/R ER316 S.S. Rod Batch: <u>1114649</u>								
	*** PLEASE NOTE****								
	IF MAKING -043A :								
	ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER								
	DSI9473								

11.03.17

110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC		0.00							
Quality Control	Memo								

11.03.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Page 2

Item ID: D2989-041 Accept  Setup Start 
Revision ID:
Item Name: Basket Lid Assembly Stop 
Start Date: 3/9/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/18/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		8 w/03/18		(70)			
125  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				1	BLR	11-328	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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(b) (5) DPP, (b) (7)(C), (b) (7)(D)

Page 3

Accept

[illegible]**Setup Start**

Stop

Abstract

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

[illegible]

Powdercoat

Powder Coating

M 115951

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

131

00000000000000000000

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 11116 of 1002

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: M116 123

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Item ID: D2989-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 3/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M, k 11/03/28

(1X)

141

Identify as per dwg & Stock Location: W/O

0.00



Packaging

Memo

0.00

Packaging

D350-607-043/1367184

11 9 11/03/28

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Q 11/03/29

MF

11-03-29

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• Picklist Print

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Page 1

Work Order ID: 67187



Parent Item: D2989-041






Parent Item Name: Basket Lid Assembly

Start Date: 3/9/2011**Required Date:** 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1  Rib		Manufactured	No			100	Each	7.0000	2	2		11.03.14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
					63628			1					
					64651			6					
✓ D2506  Label Plate		Manufactured	No			100	Each	7.0000	1	1		11.03.14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
					65279			3					
					65539			4					
✓ D2512-7  Rib		Manufactured	No			100	Each	8.0000	1	1		11.03.14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
					63629			2					
					65540			6					

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 67187

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2581

Manufactured No

100

Each

60.0000

2

2



Mounting Bracket



11.03.14

Location

Loc Qty

Loc Code

WA

60

65950

12

66500

24

66806

24

2x

✓ D2989-13

Manufactured No

100

Each

4.0000

2

2



Rib



11.03.14

Location

Loc Qty

Loc Code

WA

4

64856

4

2x

✓ D2989-19

Manufactured No

100

Each

4.0000

2

2



Rib



11.03.14

Location

Loc Qty

Loc Code

WA

4

65541

4

2x

✓ D3832-3

Manufactured No

100

Each

3.0000

1



Mesh (Lid)



11.03.15

Location

Loc Qty

Loc Code

WA

3

63234

1

64372

2

1x

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 67187

Parent Item: D2989-041


Parent Item Name: Basket Lid Assembly


Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-3 Manufactured No 100 Each 13.0000 2 2  *SY* 11.03.15


 Mesh (Lid End)


Location	Loc Qty	Loc Code
WA	13	
46308	1	
64375	6	
64947	6	

✓ D3836-041 Manufactured No 100 Each 2.0000 1 1  *SY* 11.03.14


 Rib Assembly (Basket Lid, LH)


Location	Loc Qty	Loc Code
WA	2	
64858	2	

✓ D3836-042 Manufactured No 100 Each 2.0000 1 1  *SY* 11.03.14

 Rib Assembly (Basket Lid, RH)

Location	Loc Qty	Loc Code
WA	2	
64859	2	

✓ D3852-041 Manufactured No 100 Each 4.0000 1 1  *SY* 11.03.14

 Rib Assembly

Location	Loc Qty	Loc Code
WA	4	
64594	2	
66088	2	

Wednesday, March 09, 2011 2:32:42 PM

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Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 4

Work Order ID: 67187

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3852-042

Manufactured No

100

Each

4.0000

1

1



Rib Assembly



11.03.14

Location

Loc Qty

Loc Code

WA

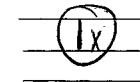
4

64593

2

66089

2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47187

PL 11-03-9

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/12

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-91-15; D3836-042 REPLACES D2989-101-15; D3836-041 REPLACES D2989-11-7; D3836-042 REPLACES D2989-21-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-91-10 (NOW ON D3836 DWG); D2989-11-21-71-15 (NOW ON D3836 DWG) AND D2989-111-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 TITLE BASKET LID ASSEMBLY DATE 08.09.24 REV. D SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

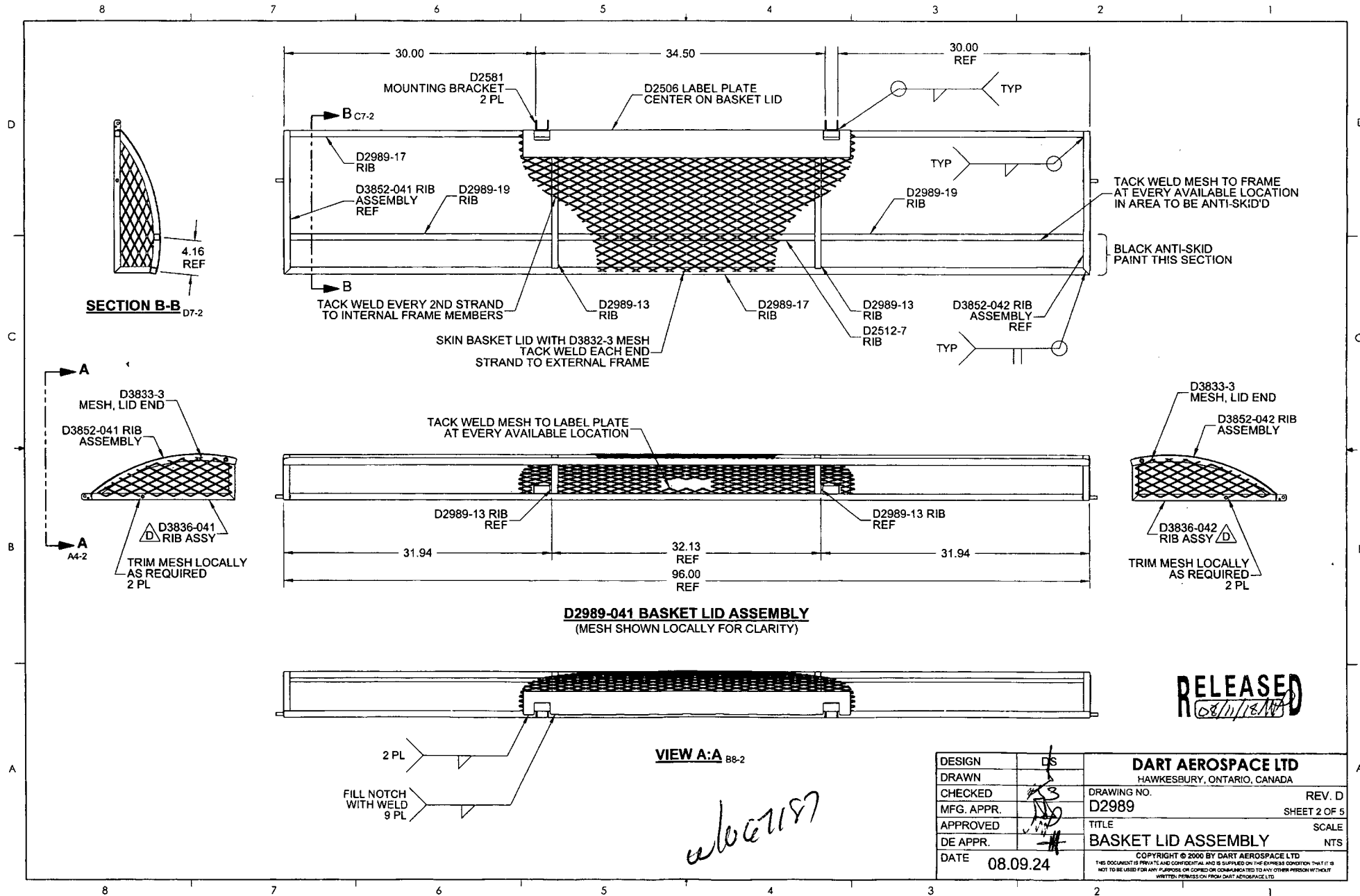
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NOTE: Date & initial all entries



DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	3	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

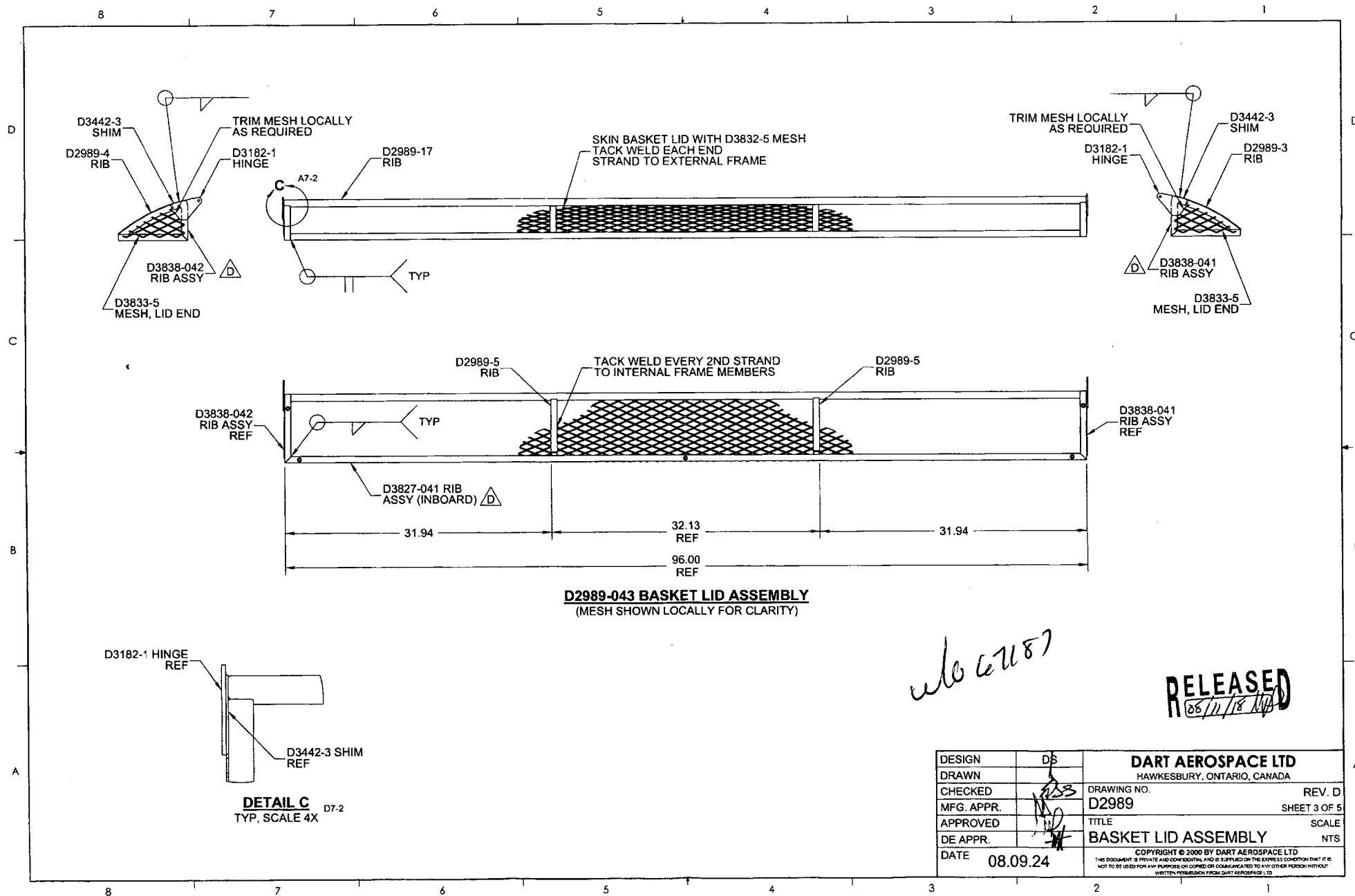
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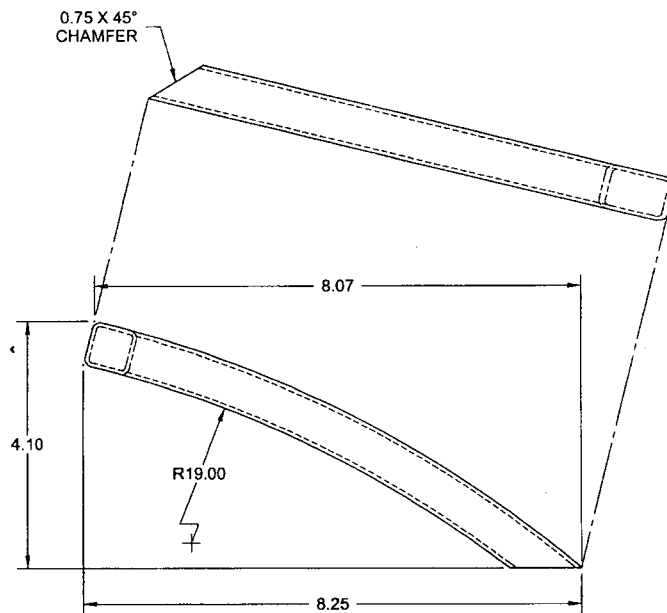
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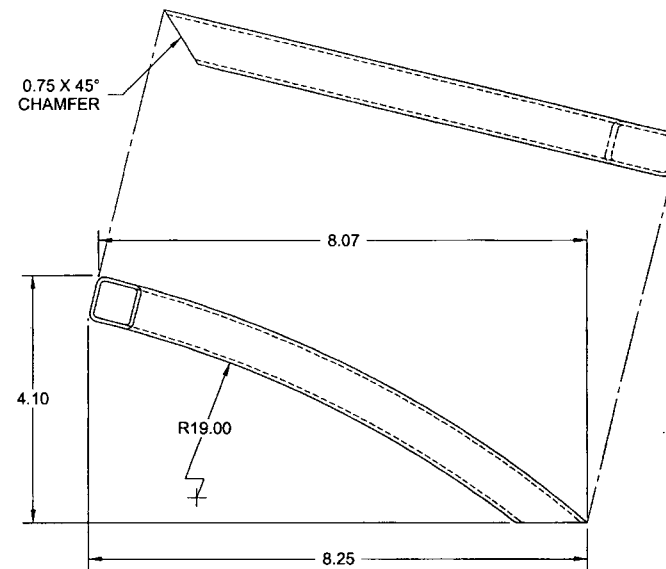
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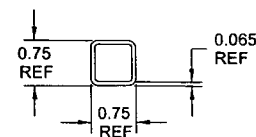
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D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

1062087

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

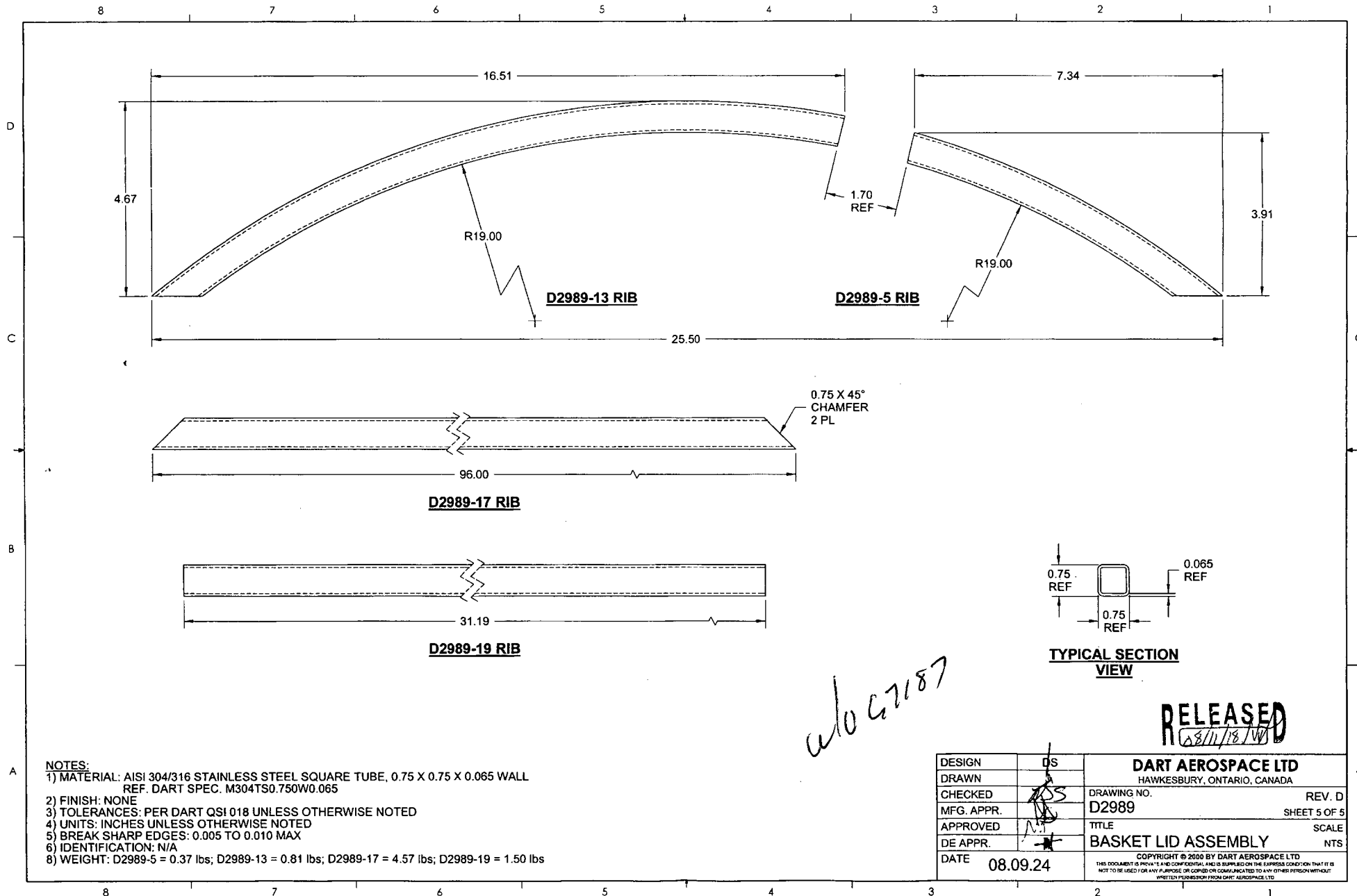
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CHECKED	DS	DRAWING NO. D2989	REV. D
MFG. APPR.	DS	TITLE BASKET LID ASSEMBLY	SHEET 5 OF 5
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